

RG 104, 8NS-104-94-077

Box 6

**8NS-104-94-077, Miscellaneous
Correspondence & Memos, 1897-1994**

Notes on Costa Rican Currency

Notes on Costa Rican Currency

5-Centimos

Costa Rica

.026

edge-.024

Wt = 15.44

Dia = .591

X-Ray - .043 + 1

Costa Rica

10-Centimo

.0365 std

Wt = 31 grains

edge .035 = .0305

Dia = 696

25-CENTIMOS

Costa Rica

$.540 = .036 = + \frac{1}{2} gr.$

Wt = 53.24

Dia = .921

NEW-DIA = .921

3 34

202

304

10-Centimo

25-Centimos

TOTAL 840

25-CENTIMOS-

Costa Rica.

.037 std.

WT. 53.24 grains

old

Dia .905 -

COSTA RICA

5-CENTIMO.

Cupro-Ni_x

PASS DIA. GAUGE

1 215 .180

2 180 .145

ANNEAL.

3 145 .100

4 115 .076

5 85 .055 X-RAY

6 65 .039 = .060

7 56 .026 = .043⁺¹

0.00 - 591 - edge = .024 - .0245

X-Ray
.039 = .043⁺¹

Costa Rica
25 Centimos

Dia blank .921 (new Dia)

WT. 53.24 grains

app 140 Ingots

Costa Rica
Special Schedule

25 Centimos

Pass	Dial	Gauge
1	5	.215
2	235	.190
anneal		
3	180	.145
4	150	.105
5	125	.080
6	100	.060
7	95	.045
8	93	.036

Edge .0355

COSTA RICA - COPRO-NIK

25-CENTIMO.

PASS	DIAL.	GAUGE
1	215	.180
2	180	.145
ANNEAL		
3	150	.105
4	125	.080
5	100	.060 X-Ray
6	95	.045 = .072
7	93	.0365 058 $\frac{1}{2}$

10-CENTIMO.

PASS	DIAL	GAUGE
1	215	.180
2	180	.145
ANNEAL		
3	150	.105
4	125	.080
5	100	.060 X-RAY
6	95	.045 = .072
7	93	.0365 = 058 $\frac{1}{2}$

DIA. 926 - edge 035-.036

.037 = $\frac{1}{2}$ gauge

DIA. 696 edge 035-.0355

COSTA RICA

CENTIMOS

5- GRANULATED 20.000.000 pes.

.026

.10 cent gauge.

.591 CUT BIANNIT CUPRO NICKEL

.571 UPSET.

.591 Finish Coin size

10- CENTIMOS 10.000.000 pes.

.035

.095 Gauge

.704 CUT BIANNIT CUPRO NICKEL

.696 UPSET Dime Project

.709 Finish Coin size

20- CENTIMOS - 4.000.000 pes.

SINGLE STRIKE

~~.037~~ .037 Gauge

CUT BIANNIT

CUPRO NICKEL

UPSET

.905 Finish Coin size - Brazil 10-Centavo die

(B.C.C.R.) Lettering on edge of finished
coins.

.0512 Finish coin.

.0++ ? gauge -

Government Costa Rica

No. Pieces 20,000,000

Date order received _____ Was master die furnished _____ No
Mint where coined Denver Was master die returned _____ No
Denomination 5 Centimo Number melts made 260 - ^{9 scraped} 251
Date coinage started 10-24-69 No. melts delivered to Coiner 251
Date coinage completed 1-12-70 Ounces per melt 5800
Cost per M _____ No. ingots per melt One
Alloy 75% Copper 25% Nickel Weight per ingot 400 lbs.
Weight per coin 15.432 ± 1 Grain Size of ingot 60"X 12 1/8" X 1 3/4"
Weight tolerance _____ Assay passing tol. on ingot _____
Fineness _____ Tol. _____ Diameter of cut blank 591
Diameter .590 Tol. ⁺ - 2 Thickness of cut blank .026
Thickness .035 Tol. ⁺ - 2 Diameter of upset blank .575
Reeded edge Yes Edge thickness upset blank .045
Plain edge No Pieces cut across strip 15
Lettered edge No Pieces cut at one stroke 18
Wastage allowed per M _____ Annealing temperature 1200°
Turn - standard or medal Standard % rejects, automatic scales _____
Year (dated) 1969 % rejects if reviewed _____
Mint mark No % good coins from ingots 50%
Was sample coin submitted Yes No. pieces per bag 20,000
Was sample strike approved Yes Weight tol., M pieces _____
Date shipped _____

Remarks:

Obv. Die Average 69,204

Rev. Die Average 60,740

"sed dime groove for upsetting.

Best results - upset cut blanks before annealing. Surplus - 227,706 oz. Annealed 240,000 oz., before upsetting, this was reason for so much surplus. Annealing and upsetting bent so many when annealed before upsetting.

5 Centimos

"

"

Drop 6 - 11-4-69

✓ 33 - 12-15-69L

✓ 7 - 12-16-69L

✓ 34 - 12-4-69V

✓ 25 - 11-14-69L

✓ 25 - 11-13-69V

✓ 55 - 11-4 - 69V

Drop 3

✓ 70 - 11-6 - 69L

✓ 38 - 11-4 - 69V

✓ 38 - 11-5 - 69V

Drop 2 - 11-28-69

10 Centimos

2027 min
total

✓ 8 - 11-28-69

✓ 8 - 11-3 - 69L

✓ 38 - 10 - 31 - 69L

✓ 76 - 10 - 30 - 69L

✓ 70 - 10 - 29 - 69L

25 Centimos ✓ 40 - 11-12 - 69L

✓ 101 - 11-10 - 69L

✓ 105 - 12-22 - 69

✓ 35 - 12-23 - 69

✓ 22 - 1 - 7 - 70

304 - final
total

one coil final special Costa Rica

Government Costa RicaNo. Pieces 10,000,000Date order received 11-17-69

Was master die furnished _____

Mint where coined DenverWas master die returned 202Denomination 10 CentimosNumber melts made 192Date coinage started 10-23-69No. melts delivered to Coiner 192Date coinage completed 12-3-69Ounces per melt 5800

Cost per M _____

No. ingots per melt OneAlloy 75% Copper - 25% NickelWeight per ingot 400 lbs.30.864 ± 2 GrainsSize of ingot 60"X 12 1/8" X 1 3/4"

Weight per coin _____

Assay passing tol. on ingot _____

Weight tolerance _____

Diameter of cut blank .696Fineness _____ Tol. .Thickness of cut blank .035Diameter .707 Tol. _____Diameter of upset blank .686Thickness .050 Tol. _____Edge thickness upset blank .042 -.043Reeded edge YesPieces cut across strip 15Plain edge NoPieces cut at one stroke 18Lettered edge NoAnnealing temperature 1450°

Wastage allowed per M _____

% rejects, automatic scales _____

Turn - standard or medal Standard% rejects if reviewed _____
perYear (dated) 1969% good coins from ingots 53,865Mint mark NoNo. pieces per bag 10,000Was sample coin submitted Yes

Weight tol., M pieces _____

Was sample strike approved Yes

Date shipped _____

Remarks:

Obv. Die Average 105,263

U. S. Dime Upsetting

Rev. Die Average 65,789

U. S. Average dime collar used

U. S. Oversize dime punch used

Government Costa Rica

No. Pieces 4,000,000

Date order received _____

Was master die furnished No

Mint where coined Denver

Was master die returned No

Denomination 25 Centimos

Number melts made 304

Date coinage started 10-23-69

No. melts delivered to Coiner 304

Date coinage completed 1-21-70

Ounces per melt 5800

Cost per M _____

No. ingots per melt One

Alloy 75% Copper - 25% Nickel

Weight per ingot 400 lbs.

Weight per coin .53.24 - 2 Grains

Size of ingot 60"X 12 1/8" X 1 3/4"

Weight tolerance _____

Assay passing tol. on ingot _____

Fineness _____ Tol. _____

Diameter of cut blank .921

Diameter .907 Tol. $\pm .002$

Thickness of cut blank .037

Thickness .055 Tol. $\pm .022$

Diameter of upset blank .897

Reeded edge No - Lettered

Edge thickness upset blank .048

Plain edge No

Pieces cut across strip 9

Lettered edge Yes

Pieces cut at one stroke 12

Wastage allowed per M _____

Annealing temperature 1450

Turn - standard or medal Standard

% rejects, automatic scales _____

Year (dated) 1969

% rejects if reviewed _____

Mint mark No

% good coins from ingots 57%

Was sample coin submitted Yes

No. pieces per bag 4,000

Was sample strike approved Yes

Weight tol., M pieces _____

Date shipped _____

Remarks:

Obv. - Die Average 57.971

Lettered on edge B.C.C.R. - We lettered before stamping. Not too satisfactory.

Rev. - Die Average 57.971

With proper adjustment on lettered segments this could be lettered after stamping and not show on coin edge and letters were plain with naked eye. Special dressing tool used for upsetting same for disc with lettering.

Costa Rica

10 Centurión total 192 Calls

10-29	70	Fin
10-30	76	"
10-31	38	"
11-3	8	"

5 Centurión total 251 ^{with} Sniped 9

11-3	38	Fin
11-4	70	"
11-5	38	"
11-6	55	"
11-13	25	"
11-14	25	"

6 Calls dropped.

3 Calls dropped.

25 Centurión total 141 Calls

11-10	101	Fin
11-12	40	

Cards finished
10 ~~Guatemala~~
Costa Rica
11-12-69 1.92 T

Complete

Cards finished
Costa Rica
5 Centavos
11-12-69 2.01 T

Cards finished

Costa Rica

25 Centavos

Ex 11-14-69 1.01

Roll Costa Rica

25 centimeters -

.037 thick

Dia. blank - 921

wt 53.24

140 coils

RR

UNITED STATES GOVERNMENT

Memorandum

TO : M&R, Coining, Cash & Deposits, Assay and
Mechanical Divisions

DATE: September 22, 1969

FROM : Cost Accounting

SUBJECT: Job Numbers for Costa Rica 5, 10 and 25 Centimos Coins

<u>M&R Ingot</u>	<u>Dept.</u>	<u>Job Charge</u>
Costa Rica Ingots	7700	7771
<u>Coining Division</u>		
<u>Process Weighing</u>	8100	8171 5 Centimo
	8100	8172 10 Centimo
	8100	8173 25 Centimo

Rolling & Blanking

Rolling Includes - Rolling, Slab Annealing and Slittering of Ingots.

	<u>Dept.</u>	<u>Job Charge</u>
Rolling	8200	8271-R 5 Centimo
Blanking	8200	8271-B 5 Centimo
Rolling	8200	8272-R 10 Centimo
Blanking	8200	8272-B 10 Centimo
Rolling	8200	8273-R 25 Centimo
Blanking	8200	8273-B 25 Centimo

Annealing

8300	8371 5 Centimo
8300	8372 10 Centimo
8300	8373 25 Centimo

Upsetting

8500	8571 5 Centimo
8500	8572 10 Centimo
8500	8573 25 Centimo

Selecting

Blanks	8800	8871-2 5 Centimo
Coins	8800	8871-3 5 Centimo
Blanks	8800	8872-2 10 Centimo
Coin	8800	8872-3 10 Centimo
Blanks	8800	8873-2 25 Centimo
Coin	8800	8873-3 25 Centimo

COSTA RICA

CENTIMOS

5- COT BLANCO 20.000.000 pes.

.026 Gauge,

+ or - 2 grain

.591 CUT BLANCO

COPRO NICKEL

.574 UPSET.

.571 Finish Coin size

15.4324 grains

1 gram -

10- CENTIMOS:

10.000.000 pes.

.035

.035 Gauge

+ or - 1/2 grain

.709 CUT BLANCO

COPRO NICKEL

.696 UPSET

.709 Finish Coin size

wt. 2 grains

30.8648 grains

25- CENTIMOS -

4.000.000 pes.

SINGLE STRIKE

.0394 Gauge

CUT BLANCO .921 COPRO NICKEL

141 grs

.021 UPSET

.905 Finish COIN size

+ or - 2 grain

.0512 Finished coin

(B.C.G.R.)

wt. 3.45 grains

old ~~.037~~ Gauge - .031 + ?

53.24 grains

new .036 " opp.

grain = gram

- 0.0648

COSTA RICA

CENTIMOS

5- ~~GRAMO~~ 20.000.000 pes.

.026 Gauge,

.0591 CUT BIANIT

COPRO NICKEL

for - 1 gr

.574 UPSET.

.591 Finish Coin size

15.4324 grains

1 gram -

10- CENTIMOS 10.000.000 pes.

X-Ray.

058.

.035 Gauge

.709 CUT BIANIT

COPRO NICKEL

for - 1 1/2 gr

.696 UPSET

.709 Finish Coin size

wt. 2 grams

31 gra.

30.8648 grains

25- CENTIMOS - 4.000.000 pes.

SINGLE STRIKE

~~.0394 Gauge~~COPRO NICKEL

921 CUT BIANIT

UPSET

.905 Finish Coin size

for - 2 grams

.0512 Finished coin

(B.C.C.R.)

^{44.25}

wt. 3.45 grams

Dauge - .031 + ?

53.24 grains

new .037

25 - 29,780. Caens-perdagat.

grain = gram -

- 0.0648

Costa Rica Blank size

25 - .038 904

Deck Drifters

Blank weight 4.35 grains -

53.24 grains top - 2 -

Costa Rica Blank





Notes on Costa Rican Currency

ACCUPLICE PRO
The Costa Rican

